

# Work Order ID 69506

Wednesday, May 11, 2011 1:46:38 PM



Item ID: D4381-1	Accept		Setup	Start	
Revision ID: <del>PRELIM</del>				Stop	
Item Name: X-tube Strap Bumper					
Start Date: 5/11/2011	Start Qty: 100.00		Cust Item ID:		
Required Date: 5/11/2011	Req'd Qty: 100.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>CL</u>	Date: <u>11/05/11</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4381	PA1 A <u>11.11.17</u>								
100		0.00							
	PURCHASING								
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>14070</u>								
	Manufacture as per Dwg D4381								
	Possible Supplier: VIP Rubber Company, Inc								
	Material release note required								
110		0.00							
	Receive & Inspect for Damage & Mat'l Certs								
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120		0.00							
	QC6- Inspect dimensions to drawing								
QC	Memo	0.00							
Quality Control	Check dims to dwg								
	<u>Call Chris R.</u>								



**PRELIMINARY ISSUE**

CL 11/05/11 100

Rec'd 11/9 (100)

CP 11.07.04 (100)

Dart Aerospace Ltd

W/O: 69506		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/11/02		took 4 for flight test at 1 for display	CP 11/11/02	11/11/02	3	CP 11/11/02 11/11/02	S 11/11/02

Part No: D4381-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 69506

Wednesday, May 11, 2011 1:46:38 PM



Page 2

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Required Date: 5/11/2011	Req'd Qty: 100.00		Customer:	
Reference:				

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <i>ST 139.</i>	0.00				<i>98</i>	<i>counted</i>		
Packaging	Memo	0.00				<i>/</i>	<i>11/11/15</i>		
Packaging								<i>8011-11-16.</i>	
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							<i>11/11/17</i>
Quality Control									<i>11.07.04</i>

## POSITIVE RECALL

EFFECTIVE 11/02/11 AUTH *W*  
RELEASED *CP* DATE 11.11.02

PARTS ARE OK TO D4381 Rev.A

*CP 11.11.02*

NOTE: THERE ARE NO LONGER 100 PIECES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, May 11, 2011 1:46:36 PM

Page 1

Work Order ID: 69506



Parent Item: D4381-1



Parent Item Name: X-tube Strap Bumper


Start Date: 5/11/2011

Required Date: 5/11/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP REV:A 11.05.10 new issue DD verf;JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4381-1P  X-tube Strap Bumper		Purchased	No			110	Each	0.0000	1	100		5/24/11	100

ST 1350

PPA SN 76482

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

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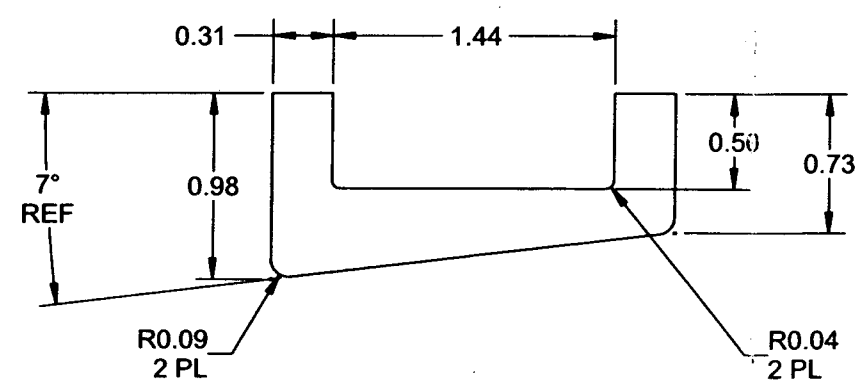
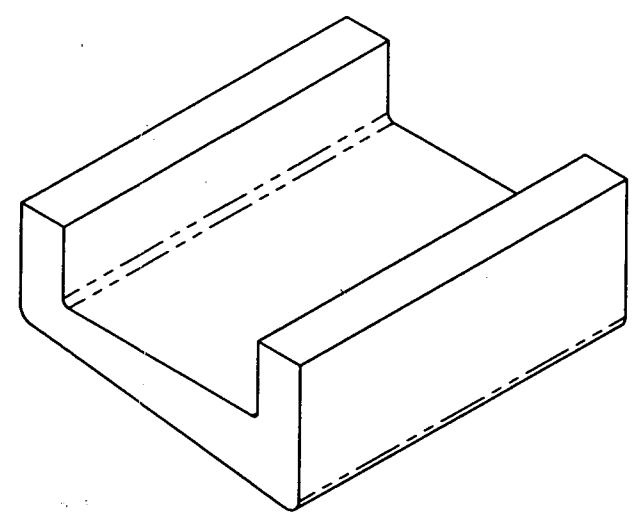
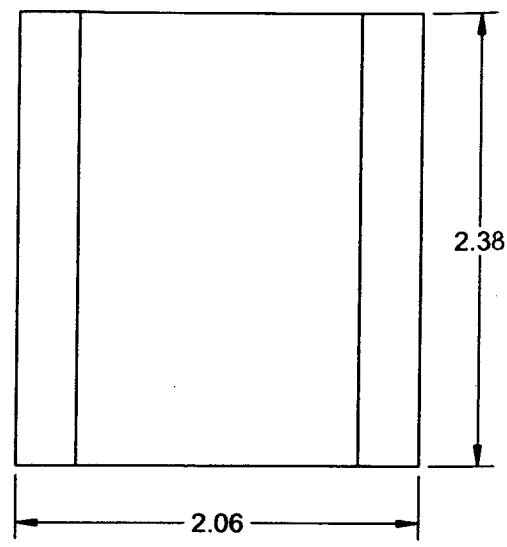
A

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PRELIMINARY ISSUE

CP 11.05.02

**D4381-1 X-TUBE STRAP BUMPER**

- NOTES:
- 1) MATERIAL: POLYURETHANE, 85 DUROMETER, BLACK
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.11 lbs APPROX

PAI	NEW ISSUE	AJS	11.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. A
MFG. APPR.		D4381	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE STRAP BUMPER	NTS
DATE	11.04.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

\*\*\*PO REPRINT\*\*\*

Purchase Order ID PO14070

Purchase Order Date 5/11/2011

PO Print Date 5/12/2011

Page Number 1 of 1

Order From :

VU-VIP001

VIP RUBBER COMPANY INC.  
540 SOUTH CYPRESS STREET  
LA HABRA, CA 90631  
US

Contact Name

Vendor Phone

562 905 3456

Vendor Fax

562 905 3460

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

USD

FOB

LA HABRA  
Destination Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4381-1P	X-tube Strap Bumper	6/24/2011 Yes	100.00 Each	FedEx PI collect	\$4.5500	\$455.00

Special Inst: AS PER DWG D4381 REV. PA1  
B69506

2		LOT NRSUR	6/24/2011 No	1.00	FedEx PI collect	\$1,250.0000	\$1,250.00
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Special Inst: ONE TIME FEE

PO Total: \$1,705.00

PO Instructions: VIP RUBBER QUOTE # 56872

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 2

Change Date: 5/12/2011

**FAXED**

TOLLANCES  
BMA COMMERCIAL  
AS QUOTE EXCEPTION  
TO NOTE #3  
8515 CAST URETHANE

INSIDE SALES MANAGER  
"YOUR ORDER HAS BEEN RECEIVED"  
DATE: 5-18-11

Sgt 1st Lt 6.24/00/

NEED FedEx ACCT  
#151713240





VIP Rubber Company, Inc.

540 S. Cypress  
La Habra, Ca. 90631

5/23/2011

## FINAL INSPECTION REPORT

<b>Customer</b> DART AEROSPACE LTD				<b>Purchase Order #</b> PO14070			
<b>Part Number/Dwg. Number</b> D4381-1P D4381 REV PA1				<b>Revision</b> PA1			
<b>Job #</b> 17978		<b>Lot #</b> 0629-11		<b>A Q L</b> Rubber 4.0 / C=0; Plastic 6.5 / C=0			
<b>Lot Size</b> 100 PCS		<b>Sample Size</b> 7 PCS		<b>Calender sheeting 3 samples per roll / C=0</b>			
<b>Dimensions Measured</b>							
<b>Dim.</b>	<b>1.44</b>	<b>.98</b>					
<b>Tol.+/-</b>	<b>.016</b>	<b>.020</b>					
<b>Range</b>	1.456	1.000					
	1.424	0.960					
<b>Descr.</b>							
1	1.430"	.961"					
2	1.433"	.963"					
3	1.430"	.960"					
4	1.434"	.961"					
5	1.435"	.963"					
6	1.435"	.962"					
7	1.432"	.963"					
8							
9							
10							
11							
12							
13							
14							
15							
16							
17							
18							
19							
20							
<b>Other Observations (If Required)</b>							
	<b>Required</b>	<b>Tolerance</b>	<b>Actual</b>		<b>Required</b>	<b>Accept</b>	<b>*Reject</b>
<b>Durometer</b>	85 URETHANE	+/- 5	84		<b>Cosmetics</b>	ALWAYS	✓
<b>Color</b>	BLACK	N/A	✓		<b>Marking</b>	N/A	N/A
<b>*Brief Description of Cosmetic Rejection:</b>							
<b>Other Inspection Notes:</b>							
<b>No. of Observations</b> 5		<b>Qty. Approved</b> 7 pcs		<b>Qty. Rejected</b> 0			
<b>Inspected By</b> Ramon Jate				<b>Date</b> 6-29-11			



VIP RUBBER COMPANY, INC.  
540 S. Cypress  
La Habra, Ca. 90631  
Ph. (562) 905-3456 / Fax (562) 905-3560

# FIRST ARTICLE INSPECTION REPORT

6/29/2011 9:57 AM



Registered to  
ISO 9001

<b>Customer</b> DART AEROSPACE LTD		<b>P/N or Drawing No.</b> D4381-1P D4381 REV PA1		<b>Rev.</b>	<b>Job #</b> 17978	<b>P.O. #</b> PO14070	<b>Material / Stock No.</b> ALL OUTSIDE PRODUCTION	<b>Color</b> BLACK	
<b>Specification</b> 85/CAST URETHANE							<b>Durometer</b> 85	<b>Tolerance</b> +/- 5	<b>Actual</b> 84
<b>Applied Tolerance:</b> RMA Commercial Plastic VIP-1 Class-1		<input checked="" type="checkbox"/>		RMA Precision Plastic VIP-1 Class-2		<input type="checkbox"/>		RMA High Precision Customer Specific	
<b>Item No.</b>	<b>Drawing Dimension (Required)</b>	<b>Tolerance (+/-)</b>	<b>Upper Limit</b>	<b>Lower Limit</b>	<b>Inspection Results (Actual)</b>	<b>Accept.</b>	<b>Reject</b>	<b>Inspection Tool Used</b>	<b>Inspection Comments</b>
1	2.380	0.032	2.412	2.348	2.362	<input checked="" type="checkbox"/>	<input type="checkbox"/>	CALIPER	
2	2.060	0.020	2.080	2.040	2.062	<input checked="" type="checkbox"/>	<input type="checkbox"/>	CALIPER	
3	1.440	0.016	1.456	1.424	1.437	<input checked="" type="checkbox"/>	<input type="checkbox"/>	CALIPER	
4	0.730	0.020	0.750	0.710	0.740	<input checked="" type="checkbox"/>	<input type="checkbox"/>	CALIPER	
5	0.500	0.016	0.516	0.484	0.489	<input checked="" type="checkbox"/>	<input type="checkbox"/>	CALIPER	
6	0.040	0.008	0.048	0.032	0.046	<input checked="" type="checkbox"/>	<input type="checkbox"/>	RADIUS GAGE	X 2
7	0.090	0.008	0.098	0.082	0.093	<input checked="" type="checkbox"/>	<input type="checkbox"/>	RADIUS GAGE	X2
8	0.980	0.020	1.000	0.960	0.961	<input checked="" type="checkbox"/>	<input type="checkbox"/>	CALIPER	
9	0.310	0.008	0.318	0.302	0.304	<input checked="" type="checkbox"/>	<input type="checkbox"/>	CALIPER	
						<input type="checkbox"/>	<input type="checkbox"/>		
						<input type="checkbox"/>	<input type="checkbox"/>		
	NOTES					<input type="checkbox"/>	<input type="checkbox"/>		
1	ACCEPT					<input type="checkbox"/>	<input type="checkbox"/>		
2	N/A					<input type="checkbox"/>	<input type="checkbox"/>		
3	ACCEPT					<input type="checkbox"/>	<input type="checkbox"/>		
4	ACCEPT					<input type="checkbox"/>	<input type="checkbox"/>		
5	N/A					<input type="checkbox"/>	<input type="checkbox"/>		
6	N/A					<input type="checkbox"/>	<input type="checkbox"/>		
7	N/A					<input type="checkbox"/>	<input type="checkbox"/>		
						<input type="checkbox"/>	<input type="checkbox"/>		
						<input type="checkbox"/>	<input type="checkbox"/>		

<b>First Article Inspection performed by:</b>	Customer Approved Dwg. <input checked="" type="checkbox"/>	Customer Supplied Sample <input type="checkbox"/>	Fit, Form & Function Required <input type="checkbox"/>
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<b>Total Observations</b> 18	<b>Total Dim. In Tol.</b> 9	<b>Total Dim. Out of Tol.</b> 0
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Additional Inspection Comments: \_\_\_\_\_

<b>Inspected By</b> RAMON SOTO	<b>Date</b> 6/29/2011
-----------------------------------	--------------------------

<b>Approved by</b> 	<b>Date</b> 6/29/2011
------------------------	--------------------------

Quality Assurance Manager Rev. G 4/1/09

All Materials  
Rubber  
Plastic  
TPE  
Molding  
Sheeting  
Extrusion  
Fabrication



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La Habra, CA 90631

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Metal Bonding  
Silicone  
PSA  
Sponge  
Cut to Length  
Co-Extrusions  
Hot Metal Tape  
And More...

## **CERTIFICATION OF CONFORMANCE**

THIS IS TO CERTIFY THAT THE MATERIAL FURNISHED ON THIS PURCHASE ORDER WAS MADE IN  
STRICT ACCORDANCE WITH THE NOTED SPECIFICATION

**Sold to:**

DART AEROSPACE LTD

1270 ABERDEEN ST  
CANADA, \*\*\*\* K6A 1K7

**Ship to:**

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ONTARIO  
CANADA, K6A 1K7

Lot #: 062911

Shipper ID: 101394

P/N and DWG#: D4381-1P, DWG#: D4381 REV PA1

Quantity	
Ordered	Shipped
100 PCS	100 PCS

Customer PO# PO14070

Cure Date: 2-Q-11

Date Shipped: 6/29/2011

Description: X-TUBE STRAP BUMPER

EXCEPTION TO DWG NOTE 3 - QUOTED RMA COMMERCIAL TOLERANCE

**Specification**

85/CAST URETHANE

RAMON SOTO JR.  
Q.C. INSPECTOR

PREPARED BY: STEVE PROG



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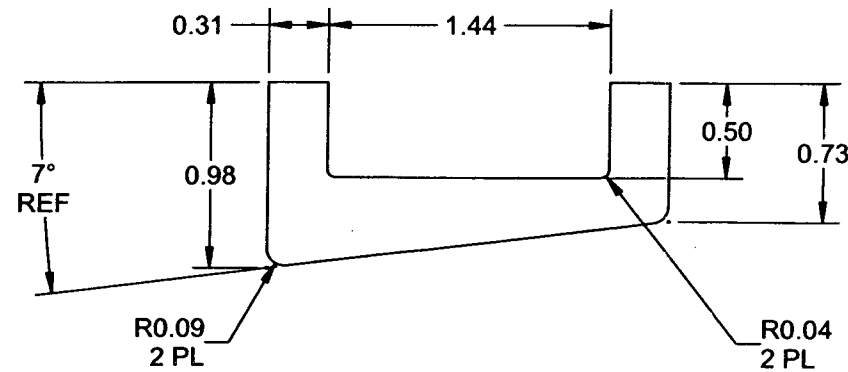
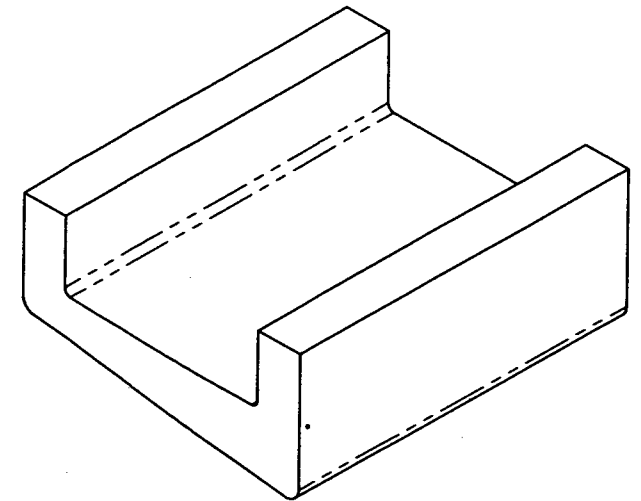
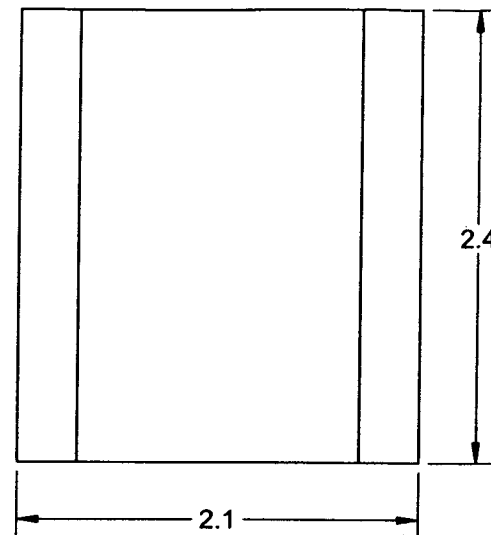
1

D

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### D4381-1 X-TUBE STRAP BUMPER

#### NOTES:

- 1) MATERIAL: POLYURETHANE, 80-85 DUROMETER, BLACK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.09 lbs APPROX

RELEASED  
2011-11-02  
MD

A	NEW ISSUE	AJS	11.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4381	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE STRAP BUMPER	NTS
DATE	11.04.13	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	